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647.9014

Job Sheet 208776



Part No: 647.9014

Job Qty: 37 ea **DAS**

Part Name: Strut Bracket

21**9-88**

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/1/20

Job Tracking No:

Due Date: 7/6/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A1 SHEET 4 IPP REV: A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	30 pcs		7/4/20	0.00	1.50	Waterjet - Flow		on 20/04/04
120	QC 2	30 pcs		7/4/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/04/04
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
130 QC 8	30 pcs	7/4/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
140 Small Fab - Brake NC - B4B	30 pcs	7/4/20	0.00 1.50	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	30 pcs	7/4/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	

DAS
APR 06 2020 40
9-89

APR 29 2020

DAS
APR 30 2020 40
9-89

190	Spray Paint - 2 - B4B	30 pcs	7/6/20	0.00 0.50	Spray Paint - 1 - B4B	DAS 41 MAY 03 2020
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 14	30 pcs	7/6/20	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	DAS 81 9-89
					QC 14 - 81	
					QC 14 - 82	
					QC 14 - 87	9-89 05 2020
210	Packaging 3-1 - Stock - B4B	30 pcs	7/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
220	QC21-SA	30 Ea	7/6/20	0.00 0.00	QC 21 - SA - 21	21 MAY 06 2020

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A1 Prog Rev: A1 2-Debur if necessary

Descriptions: 120 - QC 2

130 - QC 8

140 - Form as per drawing.

150 - QC 5

190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) PRIMER BATCH: 5265778

200 - QC 14

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.9900 sf (.033 ea)	110-Waterjet - Flow - 1	<u>5263583</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	127	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Strut Bracket	0.195Inches + 0.005 - 0.001	0.200 0.194	Diameter	
3	Strut Bracket	0.250Inches + 0.005 - 0.001	0.255 0.249	Diameter	
4	Strut Bracket	1.510Inches ± 0.005	1.515 1.505		
5	Strut Bracket	1.130Inches ± 0.005	1.135 1.125		
6	Strut Bracket	0.393Inches ± 0.005	0.398 0.388		
7	Strut Bracket	0.250Inches ± 0.005	0.255 0.245		
8	Strut Bracket	0.805Inches ± 0.005	0.810 0.800		
9	Strut Bracket	0.063Inches ± 0.005	0.068 0.058		

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